

# Work Order ID 51548

August 25, 2009 1:04:43 PM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 26/08/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 31/08/2009 Req'd Qty: 30.00

Customer:

Reference:

*09-08-25*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

*09/08/26*

*30*

*0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: C Folio Rev: C  
C □2-Debur

*Y.A 09/08/26*

*PTO*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Y.A 09/08/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: \_\_\_\_\_ Fault Category: Machined parts NCR: Yes No DQA: [Signature] Date: 05-05-10  
Scrap / Scrap QA: N/C Closed: [Signature] Date: 09-08-10

NCR: <u>51548</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/08/27</u>	<u>110</u>	<u>1 part Scrap, Machine origin moved over night when machine was shut down. 2c: Machine Malfunction.</u>	<u>[Signature]</u>	<u>Scrap and replace B# 110777</u> <u>re-adjust origin in the AM prior to starting.</u>	<u>[Signature]</u> <u>09/08/27</u>	<u>[Signature]</u> <u>09/08/27</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>09-08-27</u>

NOTE: Date & initial all entries

**Work Order ID 51548**

August 25, 2009 1:04:43 PM



Page 2

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 26/08/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 31/08/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MF  
09/08/31

30

140

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

EL

9-9-1

x30

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/07 MFMF  
09-09-03

# Picklist Print

Page 1

August 25, 2009 1:04:43 PM

Work Order ID: 51548



Parent Item: D3404-1RevC



Parent Item Name: GHW Lug

Start Date: 26/08/2009

Required Date: 31/08/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	4.2445	7.2347			
304 BAR .750 X 2.50												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

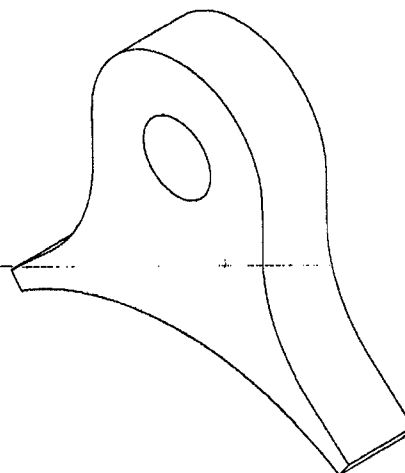
110777

4.2445

4.2445

7.2347 *ml* 09/08/26








**D3404-1 GHW LUG**

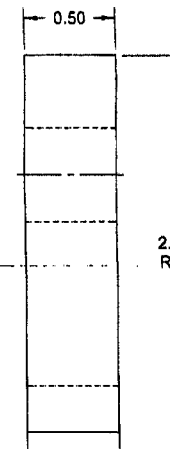
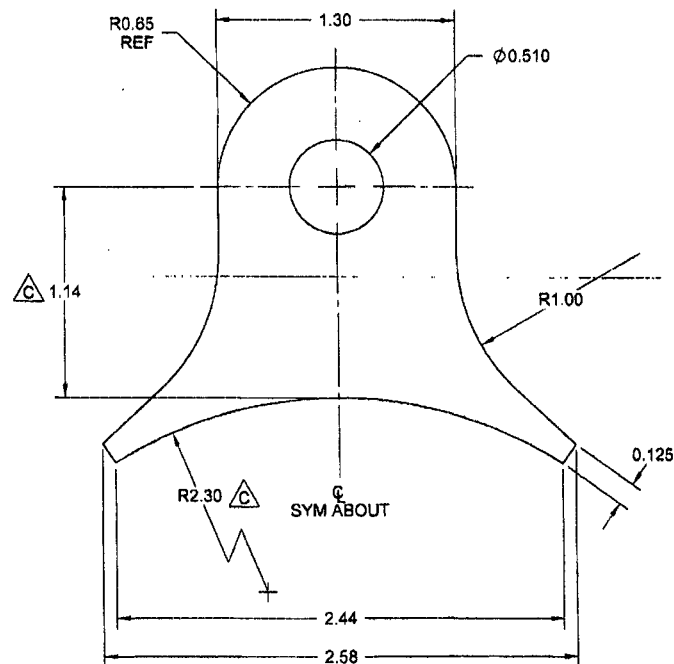
51548

**RELEASED**  
08/12/18 JWW

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



51548

RELEASED  
08/12/13

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	